January 04, 2010 1:21:54 PM

Required Date: 1/18/2010

Page 1

Item ID:

D3684-047

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

FWD LEG ASS'Y

1/5/2010

QC:

Start Otv: 4

Req'd Qty:/4.00



**Cust Item ID: Customer:** 

Reference:

**Start Date:** 

Approvals:

Process Plan: Mf

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ **Work Center ID** 

**Draw Nbr** 

Operation **Description** 

**Revision Nbr** 

Pick Kit

Rev C

Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Accept Qty Code

Reject Qty

Reject Insp. Number Stamp

100

Packaging

D3684

Memo

0.00

0.00

Packaging

110



Small Fab Small Fab

Small Fab

0.00

0.00

Memo

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivelent

on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

\*\*Ensure holes for AN3C Bolts are free of sealant. Torque Fastners as per Dwg D3684

93 ido (25

1

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					

Part No:	P	AR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	•	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B	Verification	Ammuoval	A								
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector							
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### Work Order ID 54875

January 04, 2010 1:21:54 PM



Page 2

Item ID:

D3684-047

Accept

Setup Start



**Revision ID:** 

**Item Name:** 

FWD LEG ASS'Y

**Start Date:** 1/5/2010

Required Date: 1/18/2010

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

**Approvals:** 

**Process Plan:** 

Date:

**Tooling:** 

Date:

Run Start

Reject

QC:

Date:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Stop

Stop

Reject

Sequence ID/ Work Center ID

120

QC

**Quality Control** 

Operation Description

QC5- Inspect part completeness to step on W/O

2) Siolocles

Draw

Rev.

Otv

Accept

Qty

Insp. Number Stamp

Memo

Plan

Code

130

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/01/26 HS

W/O:			WO	RK ORDER CHANGE	S		····		
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Appròval QC Inspector
							-		
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
		solution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	l)			
DATE	STEP	Description of NC		Corrective Action Section B Initial Action Description			cation	Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
							-		
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January 04; 2010 1:21:54 PM

Work Order ID: 54875

Parent Item:

D3684-047

Parent Item Name: FWD LEG ASS'Y

Comments:



Start Date: 1/5/2010

Required Date: 1/18/2010

Page 1

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Status Issued
AN3C12A		Purchased	No			110	Each	350.0000	8.0000	· ··-	- · · · · · · · · · · · · · · · · · · ·
				Warehoo	<u>use</u>	Loc	<u>Qty</u>	Loc Code			
				Loca	<u>ıtion</u>						
				Main Wa	rehouse						,
		, , , , , , , , , , , , , , , , , , ,		ST			350				Sprolocla-
		,			112314		350		<del></del>	12	Di constituti
93688-1		Manufactured	No			110	Each	2.0000	4.0000		
<b>HIII III III III III III III</b> TUD										-	·
100				Warehoo	<u>ise</u>	Loc	<u>Oty</u>	Loc Code			
				<u>Loca</u>	tion						
				Main Wa	rehouse						1 1
				ST			2				Sn 10/8/12>
					50932		2		_	6	800 coloc/22
)3689-1 	101 1981	Manufactured	No			110	Each	21.0000	4.0000		
SLEEVE											~·
				Warehou	<u>ıse</u>	Loc	<u>Qty</u>	Loc Code			
				Loca	tion						
				Main Wa	rehouse						
				ST			2				
					46051		2		_		_
				Main Wa							80 (0/01/2-
				ST12	25		19				SO (3/01/2
					50745		19		. <u> </u>	0	$\nu^{z}$

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W/O:		14,	WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•					
						,			
Part No	:	PAR #:	Fault Cateo	jory:	NCR: Yes	s No <b>DQ</b>	A:	_ Date: _	
•	Res	solution:	Disposition	):	QA: N/C	Closed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)			
DATE	STEP D	Description of NC	Corrective Action Section			Verifi	cation		Approval
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Section C		Chief Eng	QC Inspector
					:				
		-,							
		4 - 970.							
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January 04; 2010 1:21:54 PM

Work Order ID: 54875

Parent Item:

Comments:

D3684-047

Parent Item Name: FWD LEG ASS'Y



**Start Date: 1/5/2010** 

Required Date: 1/18/2010

Page 2

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3691-1		Manufactured	No		······································	110	3 5485	0.0000	4.0000	(6)		. 1
STUD D3692-1		Manufactured	No			110	Each	642.0000			83 (	100/22

**SPACER** 

Warehouse	Loc Qty	Loc Code			
<b>Location</b>					
Main Warehouse					
ST	55				
44827	8				
45672	14				
50325	33				, 1
Main Warehouse					10/01/22
ST127	587			SIS	10/01/22
50736	179		ay		
51467	408				

W/O:		The state of the s	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Appróval QC Inspector
			····						
					£				
		•	····				<u></u>		-
Part No	•	PAR #:	Fault Ca	tegory:	_ <b>NCR</b> : Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	Disposit	ion:	_ QA: N/C C	losed:		Date:	
NCR:		\	WORK OR	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
	SIEP Section A		Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
							-		

January 04,\*2010 1:21:54 PM

Work Order ID: 54875

Parent Item:

D3684-047

Parent Item Name: FWD LEG ASS'Y

Purchased

No

Comments:



**Start Date: 1/5/2010** 

Required Date: 1/18/2010

Page 3

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3693-1		Manufactured	No			110	Each	73.0000	4.0000		•	

Rod End Bearing

	Warehouse	Loc	e Oty	Loc Code	
	<b>Location</b>				
	Main Warehouse			•	
	ST		5		
	45723		5		
	Main Warehouse				
	ST127		68		
	50733		7		
	50734		61		_6_
)		110	Each	4,542.000 8.0000	

MS21043-3

Nut

Warehouse Location	Loc Oty	Loc Code
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	4462	
111819	70	
112243	29	
112314	4363	

\_\_\_\_\_ Sp 60/01/22

W/O:		WORK ORDER CHA	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Appròval QC Inspector			
Part No	);	PAR #: Fault Category:	<b>NCR</b> : Yes	No <b>DQ</b>	A:	Date: _				

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B	· · · · · · · · · · · · · · · · · · ·	Verification	Annuaral	Ammunual
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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	ate & initial a							

January 04, 2010 1:21:54 PM

Work Order ID: 54875

Parent Item:

D3684-047

Parent Item Name: FWD LEG ASS'Y

Purchased

No

Comments:



Start Date: 1/5/2010

**Required Date: 1/18/2010** 

Page 4

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin I	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS509-12C		Purchased	No	<del></del>		110	Each	126.0000	4.0000			

Nuts

<u>Warehouse</u>	<u>Lo</u>	c Qty	Loc Code		
<b>Location</b>					
Main Warehouse					
ST		126			 . 1
106993		7			Sociolar
110844		10			Sty Color,
112453		109			
	110	Each	85.0000	4.0000	

NAS509L12C

Nuts

Warehouse	Loc Qty	Loc Code			
<b>Location</b>					
Main Warehouse					
ST	85				
106993	2				1 1
112314	73		6	SK	10/01/22
112828	10				

W/O:		WORK ORDER C	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Apprôval QC Inspector			
ı										

Part No:	PAR #: Faul	It Category:	NCR: Yes No DQA:	Date:
Resolution:	Disp	position:	QA: N/C Closed:	Date:

1.	,	WORK ORDI	ER NON-CONFORMANO	CE (NCR)			
	Description of NC		Corrective Action Section B		Verification	Approval	Approval
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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				10.75			
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Verification Section C	STEP Description of NC Section A Section B Initial Action Description Sign & Verification Section C Chief Eng

QTY -047 ITEM PART NUMBER DESCRIPTION D3684-047 FWD LEG ASSEMBLY D3688-1 STUD D3689-1 3 -SLEEVE D3691-1 STUD 5 D3692-1 SPACER D3693-1 ROD END BEARING AN3C-12A BOLT MS21043-3 NAS509L-12C NUT 10 NAS509-12C NUT

£54875 -D3688-1 STUD 4> 9.20 REF ß -NAS509L-12C NUT Ð 20.74 REF D3689-1 SLEEVE ß -NAS509-12C NUT -D3691-1 STUD -AN3C-12A BOLT D3692-1 SPACER, 2X MS21043-3 NUT 2 PL D3693-1 ROD END BEARING

#### D3684-047 FWD LEG ASSEMBLY

NOTES: 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 2) UNITS: INCHES UNLESS OTHERWISE NOTED 3) IDENTIFICATION: NONE

3) IDENTIFICATION: NONE
4) DIMENSION SHOWN IS WHEN D3688-1 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
5) WEIGHT: 3.10 lbs
6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

7) TORQUE FASTENERS TO 20-25 in-lbs

8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2'
SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD					
DRAWN	RF	HAWKESBURY, ONTARIO, CA					
CHECKED	10	DRAWING NO.	REV. C				
MFG. APPR.	Sink	D3684	SHEET 4 OF 5				
APPROVED	LAN.	TITLE	SCALE				
DE APPR.	4	TRIPOD MOUNT ASSY	NTS				
DATE 08.1	2.15	COPYRIGHT © 2008 BY DART AEROSS THIS SOCIAL PROPERTY SPRINGE AND COMPROSITION AND IS SUPPLIED ON THE DESCRIPTION OF THE PROPERTY OF THE PROPER	25 TI TAHT HOSTIONOO 2222PGX				

W/O:			WOF	RK ORDER CHANGE	S			<del>. ;</del>
DATE	STEP	PRO	OCEDURE CHANG	GE .	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		t to a	· .					
				, N. 1		er es e		
Part No	•	PAR #:	Fault Catego	ory:	NCR: Yes	No DQA:	Date: _	<u>.</u>
	Re	esolution:	Disposition:	· **		osed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	R)		
DATE	CTED	Description of NC	C	n B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspector
		¥		,	,			
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